

Work Order ID 112845

February-10-14 8:58:23 AM

112845

Page 1

Item ID: D4541-8 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 2/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/13/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4541	D								

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1- Cut as per dwg(D4541-7f)
 Prog rev: D
 Dwg rev: D
 2- Deburr
2 0 De
 14-02-10

110 0.00
110
 QC Memo 0.00
 Quality Control
2 0 De
 14-02-10

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Item ID: D4541-8 Accept ***N1900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 2/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/13/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

27

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

Bend tabs as per dwg

DAS
30
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

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Item ID: D4541-8 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 2/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/13/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00							
144	HandFinish	0.00				2		14-2-12	
Hand Finishing	Memo								
146	QC7-Inspect Chemical Conversion Coat	0.00							
146	QC	0.00				2			
Quality Control	Memo								
150	Identify as per dwg & Stock Location: <u>ST 527A</u>	0.00							
150	Packaging	0.00				2			DAS 33 9-89 14-2-12
Packaging	Memo								

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Item ID: D4541-8

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 2/10/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/13/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*14-02-13**14-02-12*

Picklist Print

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Page 1

Work Order ID: 112845

Parent Item: D4541-8

Parent Item Name: Bracket

Start Date: 2/10/14

Required Date: 2/13/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.02.12 new issue DD verf:JLM
revD DD verf:JLM

IPP REV:B 13.04.23 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	459.8032	0.258	1		De 14-02-10	

Location

Loc Qty

Loc Code

MAT021

459.80317

123483

8.57

m125822

17

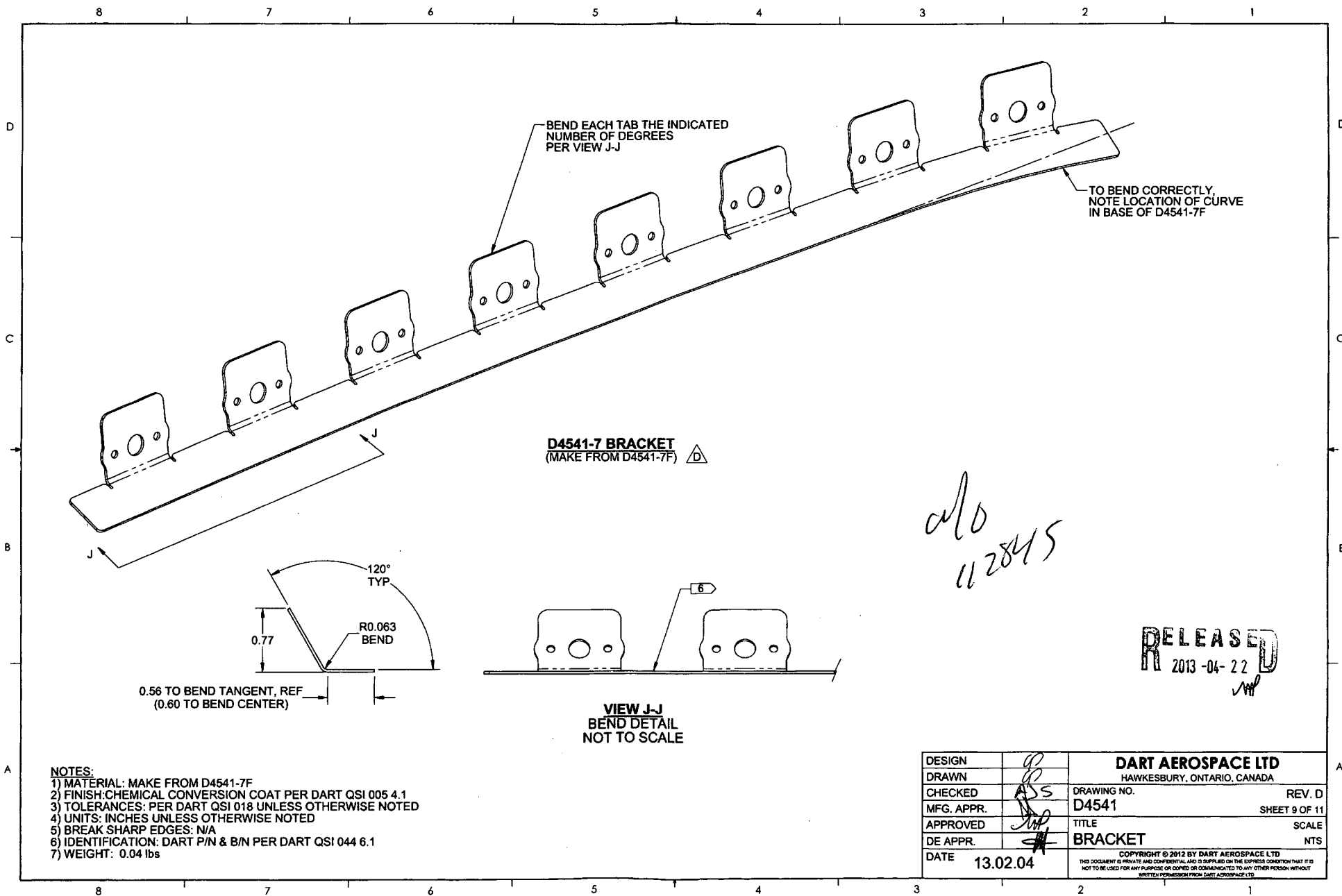
m127272

129.75317

m128054

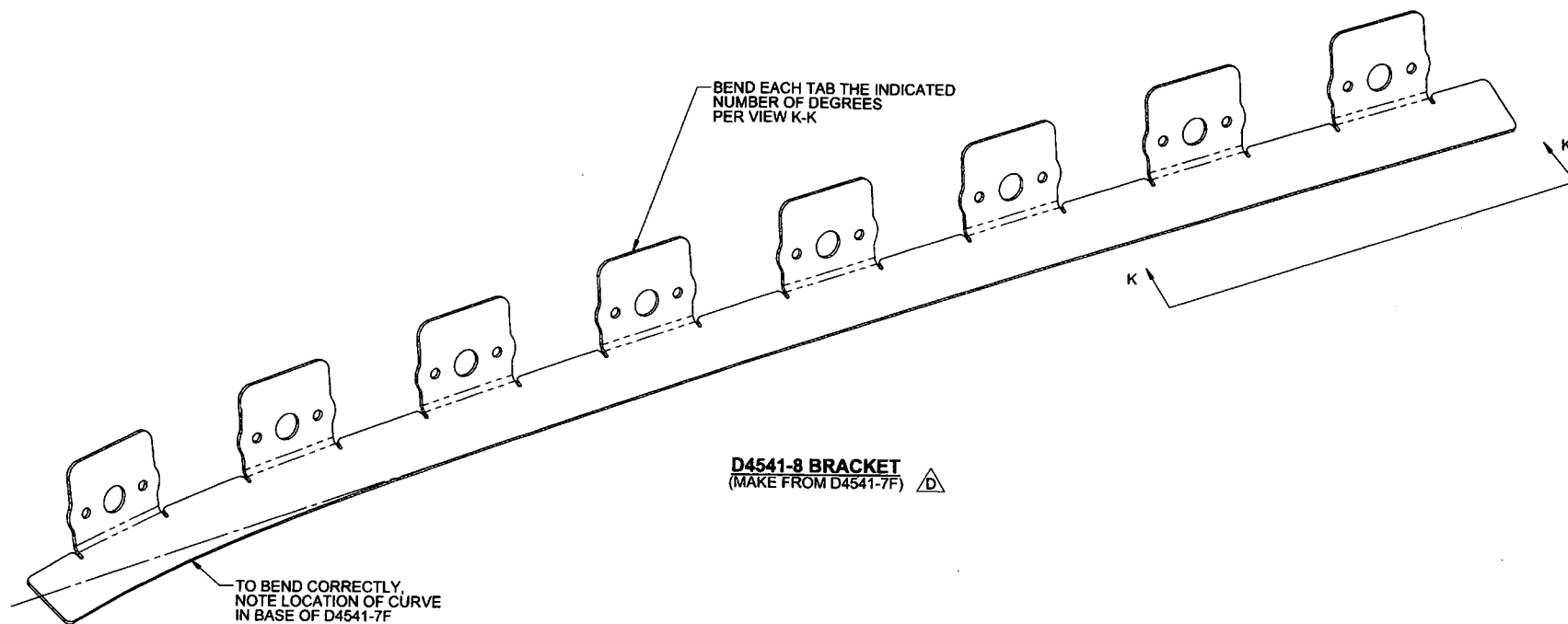
304.48

128054 → ①

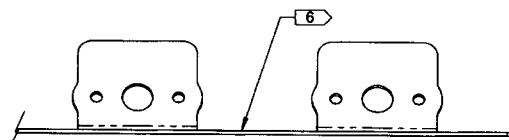


- NOTES:
- 1) MATERIAL: MAKE FROM D4541-7F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.04 lbs

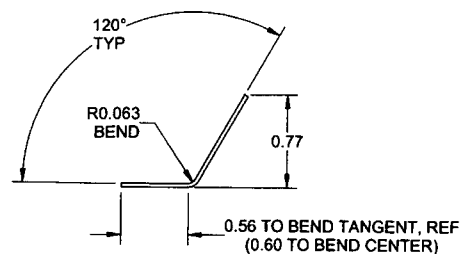
DESIGN		DART AEROSPACE LTD	
DRAWN	g	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.		D4541	SHEET 9 OF 11
APPROVED	JMP	TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	13.02.04	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D4541-8 BRACKET
(MAKE FROM D4541-7F) $\triangle D$



**VIEW K-K
BEND DETAIL
NOT TO SCALE**

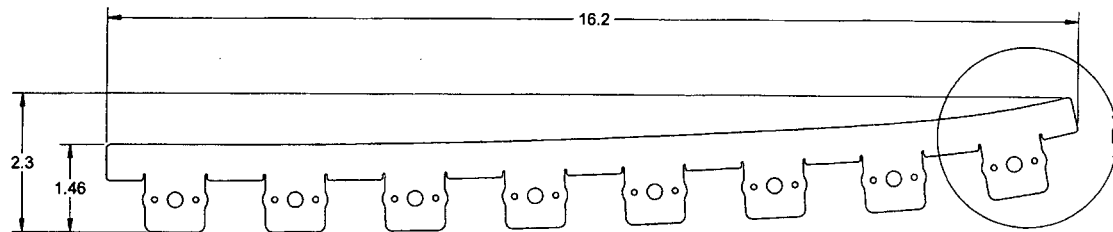


RELEASED
2013-04-22
MD

NOTES:

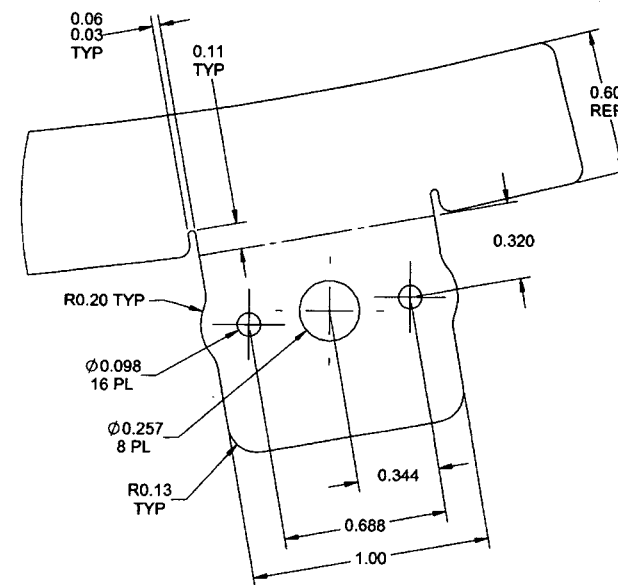
- 1) MATERIAL: MAKE FROM D4541-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
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D4541-7F FLAT PATTERN

↑
GRAIN
DIRECTION
↓



DETAIL L
TAB DETAIL
SCALE 4X

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4541-7F-REVD.DXF"

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2013-04-22

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CHECKED		DRAWING NO. D4541	REV. D
MFG. APPR.		SHEET 11 OF 11	
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DE APPR.		NTS	
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